

Date: Monday, 5/15/2006 7:09:59 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: HIGH AFT X-TUBE 412
<b>Job Number</b>	: 27083		
<b>Estimate Number</b>	: 10559		
<b>P.O. Number</b>	: N/A	<b>Part Number</b>	: D412664203
<b>This Issue</b>	: 5/15/2006	<b>S.O. No.</b>	: N/A
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D412-664-243 REV B
<b>First Issue</b>	: N/A	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 27082	<b>Drawing Revision</b>	: B
	<b>Type</b>	<b>Material</b>	: N/A
	: LANDING GEAR	<b>Due Date</b>	: 5/30/2006
<b>Written By</b>	: <u>SEE COMMENT BELOW</u>	<b>Qty:</b>	1
<b>Checked &amp; Approved By</b>	: <u>SEE ABOVE USER</u>	<b>Um:</b>	Each
<b>Comment</b>	Est Rev:E 04.02.16 Reformat; Added D3189-1 K/DS Est Rev:F 06-03-29 Remove Coments on Pick List JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D412-664-203 CHG 003

KG 06/06/15 (2)

2.0	D6009129	Crosstube Material
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6009-129 Crosstube 25942

Check OD = 3.500"; ID = 2.250"

MS 06/05/15 1

3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand &amp; install plugs DT8534 on both ends as per Folio FA166

2-Turn first side as per Folio FA166

3-Deburr &amp; Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243.

MS 06/05/15 1

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
-----	-----	------------------------------



Comment: INSPECT ALL DIM TO DIM SHEET

MS 06/05/15 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 5/15/2006 7:09:59 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 27083

Part Number: D412664203

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
-----	------------	----------------------------



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA166

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243.

3-Polish entire outside surface of crosstube

4- Remove sand and plugs

5-Scribe part # and batch # using vibrating stylus as per Dwg D412-664-243

MS 06/05/15 1

6.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

MS 06/05/15 1

7.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

BG 06-05-17 1

8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

IT 06-05-17

9.0	QC3/5	INSPECT WORK/WING WALK
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Comment: Inspect work & Chemical conversion Coat

DP 06-5-23

10.0	BENDING	BENDING MACHINE
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Comment: BENDING MACHINE

Bend tube as per Dwg D412-664-243 using CNC bender program 412-af and Folio FT010

DP 06-5-23

11.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

06-05-30 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube as per Dwg D412-664-243 using drill Jig DT8550 &amp; DT8551

2-Ream hole to finish size in tube as per Dwg D412-664-243 using drill Jig DT8550 &amp; DT8551. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-Deburr &amp; Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243

FC 06-05-30

FC 06-05-30

PM 06-05-31

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FF

06-05-31

A.M

06-05-31

①

PTU

14.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 0380r

Issue P/O: 1386 LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

C 206/06/02 ①

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

✓ AR 06/06/09

16.0

QCC

DIMENSIONAL CHECK



Comment: Inspect for damage &amp; ensure results are as per Dwg D412-664-203

06-06-12 ①

① PRO

17.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

FC 06 06 12

MM

06 06 13

①

①

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
060601	13	Add Qc5 before NOT, Permanent change. <i>[Signature]</i>				<i>[Signature]</i>	<i>[Signature]</i> 060601	
060612	16	QC5 by: <i>[Signature]</i> 060602 (1) Add Qc5, Remove Qc6 permanent change <i>[Signature]</i>					<i>[Signature]</i> 06-06-12	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: *[Signature]* Date: 06/06/16

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 27083

Part Number: D412664203

Job Number:



Seq. #:	Machine Or Operation:	Description :
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18.0	QC14	Inspect Spray Paint
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*Jan 06 15 0*

Comment: Inspect Spray Paint  
Wrap in plastic bag to protect from scratches

19.0	D2856600	Abrasion Strip
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Comment: Qty.: 1.7640 f(s)/Unit Total : 1.7640 f(s)  
Pick:

Qty	Part number	Description	Batch
2	D2856-600(Cut to 10.090")	Abrasion Strip	<u>B24328</u> <i>IT 06-06-15</i>

20.0	D2856600	Abrasion Strip
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Comment: Qty.: 1.0080 f(s)/Unit Total : 1.0080 f(s)  
Pick:

Qty	Part number	Description	Batch
1	D2856-600(Cut to 10.870")	Abrasion Strip	<u>B24328</u> <i>IT 06-06-15</i>

21.0	D28961	Support
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Pick:

Qty	Part number	Description	Batch
1	D2896-1	Support	<u>B21740</u> <i>IT 06-06-15</i>

22.0	D31891	Chafing Shield
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Pick:

Qty	Part number	Description	Batch
2	D3189-1	Chafing Sheild	<u>B25658</u> <i>IT 06-06-15</i>

23.0	MS2192028	Clamp(per MIL-DTL-8783C)
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Pick:

Qty	Part number	Description	Batch
4	MS21920-28	Clamp	<u>m100479</u> <i>IT 06-06-15</i>



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

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User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 27083

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

MS2192030

clamp(per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 MS21920-30

Clamp

M11729 25 06-06-15

25.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Assemble as per Dwg D412-664-203

27 06 06-15

26.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP 06-6-14

27.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

28.0

AN640A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch:

M19099 ✓

29.0

AN641A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch:

M19633 ✓

30.0

AN960JD616

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Washer

Batch:

M100191 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 27083

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

MS21042L6

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

Batch: M19099

Po 6/6/16 ①

32.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

C206 1/6/06 ①

33.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-664-203

Location:           

PPP Rev: D

C206 1/6/06

①

34.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DD 20/06/16 ①

Job Completion



W 06-06-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	
<b>Description:</b> Crosstube Assembly (412 High Aft)	<b>Part Number:</b>	<b>D412-664-243</b>
<b>Inspection Dwg:</b> D412-664-243 <b>Rev:</b> B		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.684	+0.005/-0.000	2.688	✓			
	2.748	+0.005/-0.000	2.753	✓			
	2.884	+0.005/-0.000	2.889	✓			
	3.019	+0.005/-0.000	3.024	✓			
	3.163	+0.005/-0.000	3.168	✓			
	3.308	+0.005/-0.000	3.313	✓			
	3.429	+0.005/-0.000	3.434	✓			
	2.990	+0.005/-0.000	2.994	✓			
	2.618	+0.005/-0.000	2.624	✓			
	0.200	+/-0.010	.200	✓			
	R0.063	+/-0.010	.063	✓			
	R0.500	+/-0.010	.500	✓			
	4.971	+/-0.001	4.971	✓			
SIDE B	2.684	+0.005/-0.000	2.689	✓			
	2.748	+0.005/-0.000	2.752	✓			
	2.884	+0.005/-0.000	2.889	✓			
	3.019	+0.005/-0.000	3.024	✓			
	3.163	+0.005/-0.000	3.167	✓			
	3.308	+0.005/-0.000	3.312	✓			
	3.429	+0.005/-0.000	3.433	✓			
	2.990	+0.005/-0.000	2.994	✓			
	2.618	+0.005/-0.000	2.622	✓			
	0.200	+/-0.010	.200	✓			
	R0.063	+/-0.010	.063	✓			
	R0.500	+/-0.010	.500	✓			
	4.971	+/-0.001	4.971	✓			
	124.09	+/-0.020	124.09	✓			

<b>Measured by:</b> M8	<b>Audited by:</b> BG	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 06/05/15	<b>Date:</b> 06.05.17	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.16	New Issue (P/O D412-664-203)	KJ/JLM	
B	06.03.09	Dwg Rev updated	KJ/JLM	

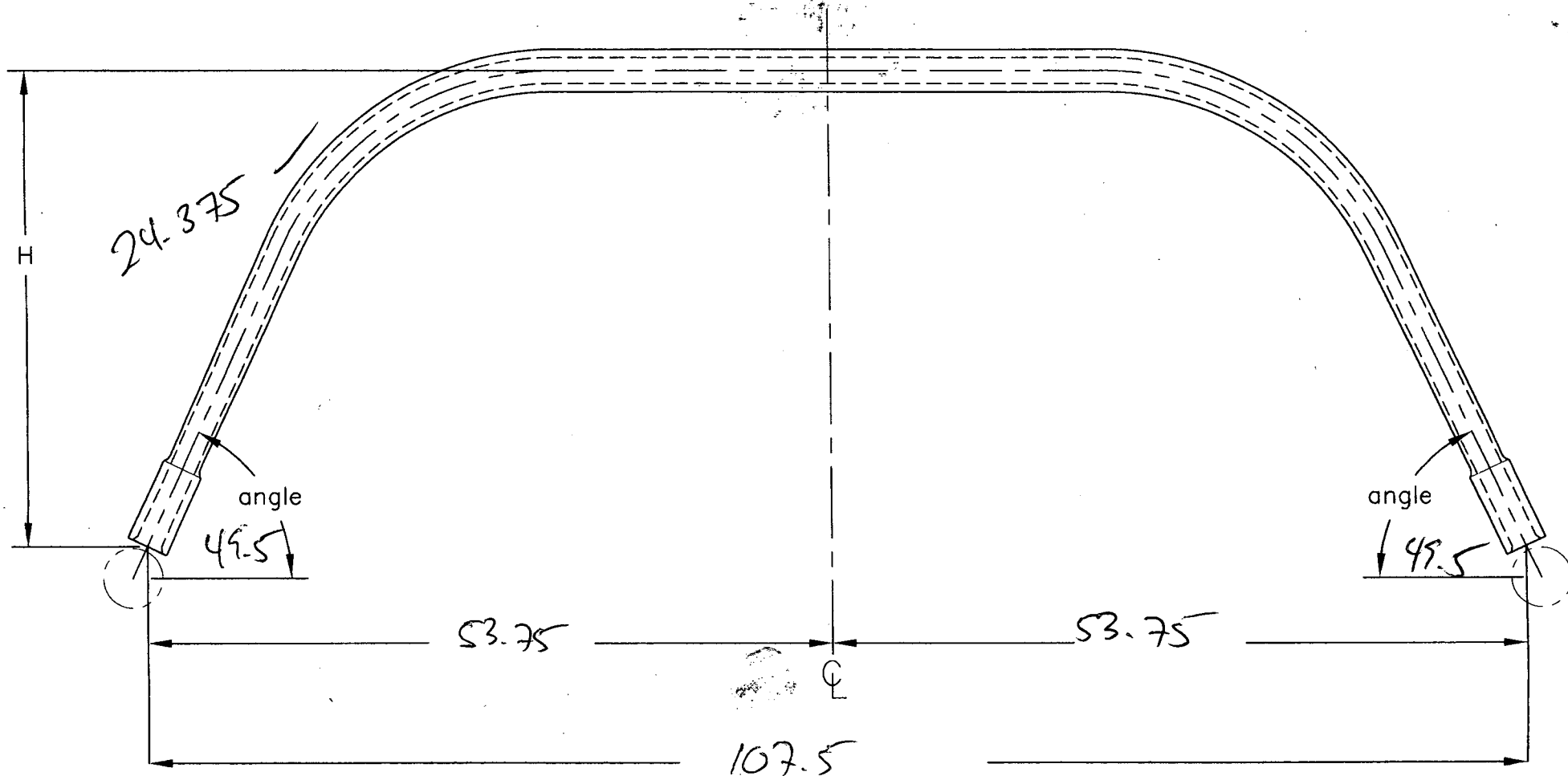
W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



DATE: 06-05-30

DESCRIPTION: D412-664-203

BATCH NO: 27083

DRAWING: 412-664-243(R: B)

H: 24.37 } .060

1/2 SPAN: 53.72

TOTAL SPAN: 107.44

ANGLE: 50<sup>+2</sup>

*[Signature]*  
06-05-30





# HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3  
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 34275

A.M.O. Number: 46/90

## NON-DESTRUCTIVE TESTING REPORT

### AIRCRAFT / COMPONENT INFORMATION

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

### INSPECTION REQUIREMENTS

Carry out FPI of (12) cross tube (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty (7) P/N D058-676-201 S/N's B19627, B19633, B19631, B19635, B19632, B19624 & B19630

Qty (5) P/N D412-664-203 S/N's B27082, B26672, B27084, B27083 & B26673



RADIOGRAPHY



ULTRASONIC



PENETRANT



MAGNETIC PARTICLE



EDDY CURRENT

### INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on (12) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)

Ardrox 970P25E Batch #04B503.

(12) cross tubes PASSED inspection.

~~THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH  
THE APPLICABLE STANDARDS OF AIRWORTHINESS~~

INSPECTED BY: 

DATE

June 8, 2006

INSPECTION  
STAMP(S)

Not Required

### CUSTOMER INFORMATION

CUSTOMER Dart Aerospace

P.O. NUMBER

1386

ADDRESS:

CONTACT NAME:

LABOUR

@

\$

MATERIALS

@

TRAVEL EXPENSES

@

GST

HOTEL EXPENSES

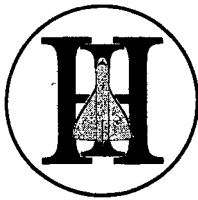
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PST

INVOICE NO.

TOTAL \$

WHITE COPY - INSPECTION FILE • YELLOW COPY - CUSTOMER • PINK COPY - ACCOUNTANT



# HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3  
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 34275

A.M.O. Number: 46/90

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### AIRCRAFT / COMPONENT INFORMATION

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

### INSPECTION REQUIREMENTS

Carry out FPI of (12) cross tube (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty (7) P/N D058-676-201 S/N's B19627, B19633, B19631, B19635, B19632, B19624 & B19630

Qty (5) P/N D412-664-203 S/N's B27082, B26672, B27084, B27083 & B26673

☐ RADIOGRAPHY

☐ ULTRASONIC

☒ PENETRANT

☐ MAGNETIC PARTICLE

☐ EDDY CURRENT

### INSPECTION REPORT

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Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)

Ardrox 970P25E Batch #04B503.

(12) cross tubes PASSED inspection.

~~THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH  
THE APPLICABLE STANDARDS OF AIRWORTHINESS~~

INSPECTED BY: 

DATE June 8, 2006

INSPECTION STAMP(S) Not Required

### CUSTOMER INFORMATION

CUSTOMER: Dart Aerospace

P.O. NUMBER 1386

ADDRESS:

CONTACT NAME:

LABOUR @

MATERIALS @

TRAVEL EXPENSES @

HOTEL EXPENSES @

\$

GST

PST

INVOICE NO.

TOTAL \$

WHITE COPY - INSPECTION FILE • YELLOW COPY - CUSTOMER • PINK COPY - ACCOUNTANT



# HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3  
Tél: (514) 636-1000 • Fax: (514) 636-0031

W.O. No 34275

A.M.O. Number: 46/90

## NON-DESTRUCTIVE TESTING REPORT

### AIRCRAFT / COMPONENT INFORMATION

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

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Qty (7) P/N D058-676-201 S/N's B19627, B19633, B19631, B19635, B19632, B19624 & B19630  
Qty (5) P/N D412-664-203 S/N's B27082, B26672, B27084, B27083 & B26673



RADIOGRAPHY



ULTRASONIC



PENETRANT



MAGNETIC PARTICLE



EDDY CURRENT

### INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on (12) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)  
Ardrox 970P25E Batch #04B503.

(12) cross tubes PASSED inspection.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH  
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY:

  
S. FLETCHER

DATE:

June 8, 2006

INSPECTION  
STAMP(S)

Not Required

### CUSTOMER INFORMATION

CUSTOMER: Dart Aerospace

P.O. NUMBER:

1386

ADDRESS:

CONTACT NAME:

LABOUR

@

\$

MATERIALS

@

GST

TRAVEL EXPENSES

@

PST

HOTEL EXPENSES

@

INVOICE NO.

TOTAL \$

WHITE COPY-INSPECTION FILE • YELLOW COPY-CUSTOMER • PINK COPY-ACCOUNTANT